



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4956-23
Job Sheet 179736



Part No: D4956-23

Job Qty: 5 ea

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEETS 4,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/04
100	Waterjet	5 pcs	7/18/18	7/18/18	0.00	1.39	Waterjet1		SC 18/07/04
120	QC	5 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
130	Brake NC	5 pcs	7/18/18	7/18/18	0.15	0.22	Brake NC 1		DAS 38
140	QC	5 pcs	7/18/18	7/18/18	0.00	0.00	QC5		38
150	HandFinish	5 pcs	7/18/18	7/18/18	0.00	0.48	HandFinish4		JUL 19 2018
160	QC	5 pcs	7/18/18	7/18/18	0.00	0.00	QC3		18-07-25
170	Packaging	5 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-2	FN-002	18-7-26
180	QC21-SA	5 Ea	7/18/18	7/18/18	0.00	0.00	QC21		DAS 21 JUL 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	6.2500 sf (1.25 ea)	90-Start up Operation	

Rockguard 138886

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	6	215	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	0.190	Diameter
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290	0.304	
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290	0.305	
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875	1.888	
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990	2.005	
6	Wearshoe	6.750Inches ± 0.010	6.760 6.740	6.754	
7	Wearshoe	11.500Inches ± 0.010	11.510	11.500	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																																																																			
Date : _____	Step #: _____																																																																						
Description Work Order Dev: _____																																																																							
DART AEROSPACE Container No: S089816 Part: D4956-23 Job No: 179736 Serial No/Batch: S089816 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/07/18																																																																							
			Completed By: _____ hand / Supervisor: _____ roval Verification: _____																																																																				
			QA Coordinator Approval: _____ Dart Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON K8A 1K7 CANADA TEL: 905 513 832-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																				
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			11.490	
8	Wearshoe	16.750Inches ± 0.010	16.760 16.740	16,750
9	Wearshoe	25.140Inches ± 0.010	25.150 25.130	25,140
10	Wearshoe	30.530Inches ± 0.010	30.540 30.520	30,530
11	Wearshoe	35.920Inches ± 0.010	35.930 35.910	35,920
12	Wearshoe	41.310Inches ± 0.010	41.320 41.300	41,310
13	Wearshoe	46.700Inches ± 0.010	46.710 46.690	46,700
14	Wearshoe	50.200Inches ± 0.010	50.210 50.190	50,200
15	Wearshoe	54.850Inches ± 0.010	54.860 54.840	54,850
16	Wearshoe	56.850Inches ± 0.030	56.880 56.820	56,850
17	Wearshoe	6.000Inches ± 0.030	6.030 5.970	6,000
18	Wearshoe	14.000Inches ± 0.030	14.030 13.970	14,000
19	Wearshoe	22.000Inches ± 0.030	22.030 21.970	22,000
20	Wearshoe	30.000Inches ± 0.030	30.030 29.970	30,000
21	Wearshoe	38.000Inches ± 0.030	38.030 37.970	38,000
22	Wearshoe	45.000Inches ± 0.030	45.030 44.970	45,000
23	Wearshoe	54.000Inches ± 0.030	54.030 53.970	54,000

Plex 6/21/18 7:35 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
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